

Work Order ID 126402

November-06-14 11:35:06 AM

126402

Page 1

Item ID: D412-630-034

Revision ID:

Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14 Start Qty: 4.00 *4*

Required Date: 11/28/14 Req'd Qty: 4.00 *4*

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev N								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & create labels per PPP.D412-630-034 CHG004								
110	Small Fab	0.00							
110	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D412-630 p.14								
	Coat all hardware with LPS3 rust inhibitor								
	A/R LPS3 batch: <u>1123777</u>								
	COAT exposed HARDWARE WITH LPS PROCYON.								
	A/R LPS PROCYON BATCH: <u>1122900</u>								

DAS
6
9-89

JUN 11 2015

42

15 06 89

DAS
36
8-89

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4
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DAS
6
9-89

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Item ID: D412-630-034

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 11/28/14 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034								
	Location: <u>6692</u>								
	PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

JUN 16 2015

**DAS
6
9-89**

**DAS
02
9-89**

ML5

JUN 16 2015

ML5 JUN 16 2015

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Work Order ID: 126402

126402

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
 IPP rev B ecn1019, added D2807-041 EC verified by:DD
 IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D
 13.06.07 PER CHG004 DD vef:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 *AN310C8* Nut		Purchased	No			110	Each	25.0000	2	8	15/06/11	DAS 36 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST331				25					
				m129768				25		8			
AN3C21A *AN3C21A* BOLT		Purchased	No			110	Each	32.0000	2	8	15/06/11	DAS 36 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST348				32					
				M129384				7					
				M130466				25		8			
AN44C7A *AN44C7A* Eyebolt		Purchased	No			130	Each	15.0000	1	4		DAS 27 9-89	DAS 02 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST339				15					
				m127933				1					
				m129521				14		4			

DAS
6
9-89

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Work Order ID: 126402

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

AN4C10A

Purchased

No

130

Each

8.0000

4

AN4C10A

BOLT

**

DAS

27

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

ST339

8

M126105

1

M129521

7

m1311S3

4

AN4C15A

Purchased

No

130

Each

145.0000

8

AN4C15A

Bolt

**

DAS

27

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

FG

10

120360

10

ST343

135

M126175

6

M128403

9

M128634

20

M130466

50

M130716

50

m132189

8

DAS

6

9-89

AN4C6A

Purchased

No

130

Each

483.0000

4

AN4C6A

Bolt

**

DAS

27

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

ST345

469

128324

12

m125709

30

m128403

39

m130325

188

m130716

200

m130613

4

DAS

6

9-89

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Work Order ID: 126402

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

AN5C15A

Purchased No

130 Each

87.0000

2 8

AN5C15A

Bolt

DAS
6
9-89

**

DAS
27
9-89

DAS
02
9-89

JUN 09 2015

Location

Loc Qty

Loc Code

ST337

87

121162

2

M127290

31

M128429

4

M130466

50

AN8C16

Purchased No

110 Each

27.0000

2 8

AN8C16

Bolt

**

DAS
36
9-89

15/06/11
M131856 (6x)

M132169 (2x)

15/04/11
DAS
36
9-89

B129651 (Bx)

B132375 (Bx)

15/06/11
DAS
36
9-89

B127260 (4x)

Location

Loc Qty

Loc Code

ST332

27

M129443

7

M130460

14

M130664

6

D2012-107

Manufactured No

110 Each

20.0000

1 4

D2012-107

Clevis

**

Location

Loc Qty

Loc Code

WA004

20

121985

1

122241

12

124102

7

D2803-042

Manufactured No

110 Each

14.0000

1 4

D2803-042

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST474

14

108481

3

120059

11

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

D2804-042

Manufactured No

110 Each

11.0000

1 4

D2804-042

RH Step Fwd Bracket

**

15/06/11

DAS
36
9-89

Location

Loc Qty

Loc Code

ST361

11

119408

11

D2806-1

Manufactured No

130 Each

39.0000

2 8

D2806-1

Bushing

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST011

39

109120

13

124287

26

D2806-3

DAS
6

Manufactured No

130 Each

21.0000

2 8

D2806-3

Bushing

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST010

21

109121

11

124480

10

D2807-041

Manufactured No

110 Each

16.0000

2 8

D2807-041

Gas Spring

**

15/06/11

DAS
36
9-89

Location

Loc Qty

Loc Code

FG

2

89606

2

ST011

12

113107

1

120616

11

ST012

2

124281

2

B127969
8x

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Work Order ID: 126402

126402

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

D2810-5

Manufactured No

130

Each

17.0000

4

D2810-5

Strut

DAS
6
9-89

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST457

6

124237

6

ST459

11

113659

4

119420

7

JUN 09 2015

D2813

Manufactured No

110

Each

47.0000

2

8

D2813

Washer

**

DAS
36
9-89

Location

Loc Qty

Loc Code

ST011

47

107891

7

119452

20

124271

20

8

D3395-1

Manufactured No

110

Each

33.0000

4

16

D3395-1

Bushing

**

DAS
36
9-89

Location

Loc Qty

Loc Code

ST036

33

114413

13

124504

20

15

D3396-1

Manufactured No

130

Each

43.0000

2

8

D3396-1

Spacer

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST037

43

105459

1

107894

42

8

DAS
6
9-89

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Work Order ID: 126402

126402

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

D3562-042

Manufactured No

110 Each 0.0000 1 4

D3562-042

Step Weldment

MS21043-3

Purchased No

110 Each 956.0000 4 16

MS21043-3

Nut

**

**

DAS
36
9-89

DAS
36
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
GA	12	
m130186	12	
ST304	864	
m128398	16	
m129472	9	
m129521	17	
m130673	822	

M131677
16x

MS21043-4

Purchased No

130 Each 2,141.000 4 16

MS21043-4

Nut

**

DAS
27
9-89

DAS
02
9-89

JUN 09 2015

Location

Loc Qty

Loc Code

FG	40	
104603	40	
ST304	2101	
m128300	57	
m128429	57	
m128798	1249	
m128818	738	

M132382

K6

DAS
6
9-89

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Work Order ID: 126402

126402

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130

Each

176.0000

3

12

MS21043-5

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

ST304

156

116548

88

121584

11

m129795

57

m132123

12

DAS
27
9-89
JUN 09 2015
DAS
02
9-89

MS24665-302

Purchased

No

110

Each

62.0000

2

8

MS24665-302

Cotter Pin

**

15/06/11
DAS
36
9-89

Location

Loc Qty

Loc Code

ST293

62

116396

1

120521

35

m127305

26

8

MS24693-C280

Purchased

No

110

Each

26.0000

2

8

MS24693-C280

SCREW

**

15/06/11
DAS
36
9-89

Location

Loc Qty

Loc Code

ST291

26

m127305

26

8

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Work Order ID: 126402

126402

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

345.0000

6

24

NAS1515H3

Washer

**

15/06/11
DAS
36
9-89

Location

Loc Qty

Loc Code

FG

10

123301

10

ST266

335

m128635

99

m129521

236

131697 (24x)

NAS1515H4

Purchased

No

130

Each

137.0000

28

NAS1515H4

Washer

**

DAS
27
9-89
DAS
02
9-89

Location

Loc Qty

Loc Code

ST266

137

125574

37

m129499

100

28

DAS
6
9-89

NAS1515H5

Purchased

No

130

Each

252.0000

28

NAS1515H5

Washer

**

DAS
27
9-89
DAS
02
9-89

Location

Loc Qty

Loc Code

FG

40

103691

40

ST266

212

125574

12

m130783

200

28

DAS
6
9-89

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Work Order ID: 126402

126402

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5L

Purchased

No

110

Each

211.0000

4

16

***NAS1515H5I ***

Washer

15/06/11
DAS
36
9-89

Location

Loc Qty

Loc Code

FG

40

103691

40

ST266

171

M130005

2

M130466

169

NAS1515H8

Purchased

No

110

Each

41.0000

4

16

NAS1515H8

Washer

15/06/11
DAS
36
9-89

Location

Loc Qty

Loc Code

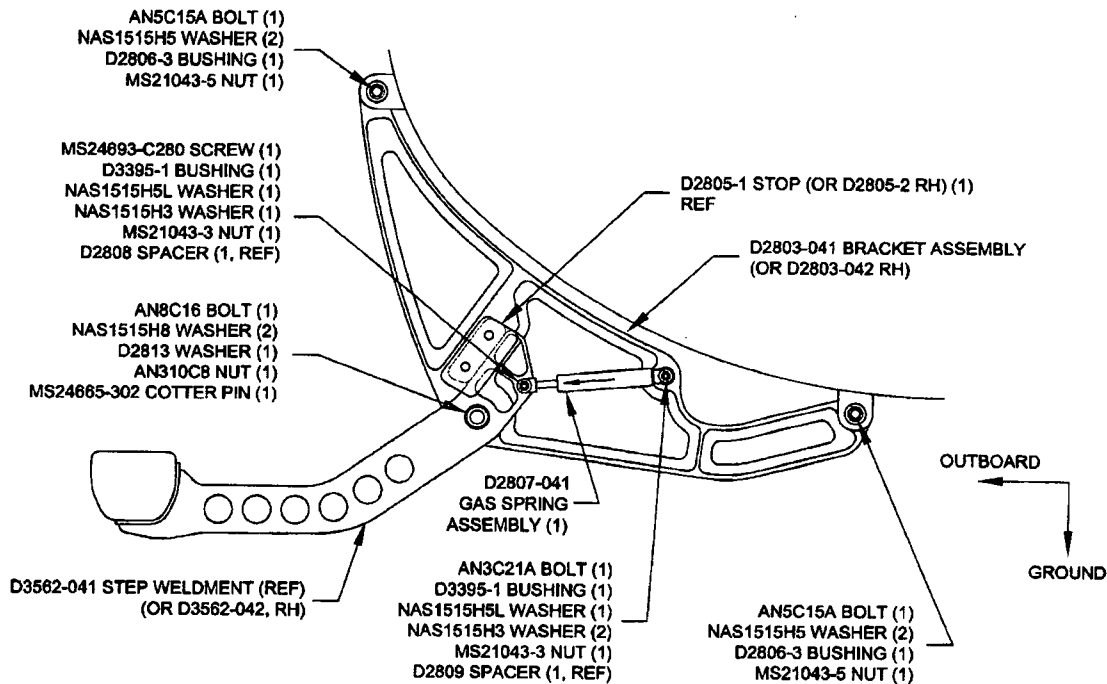
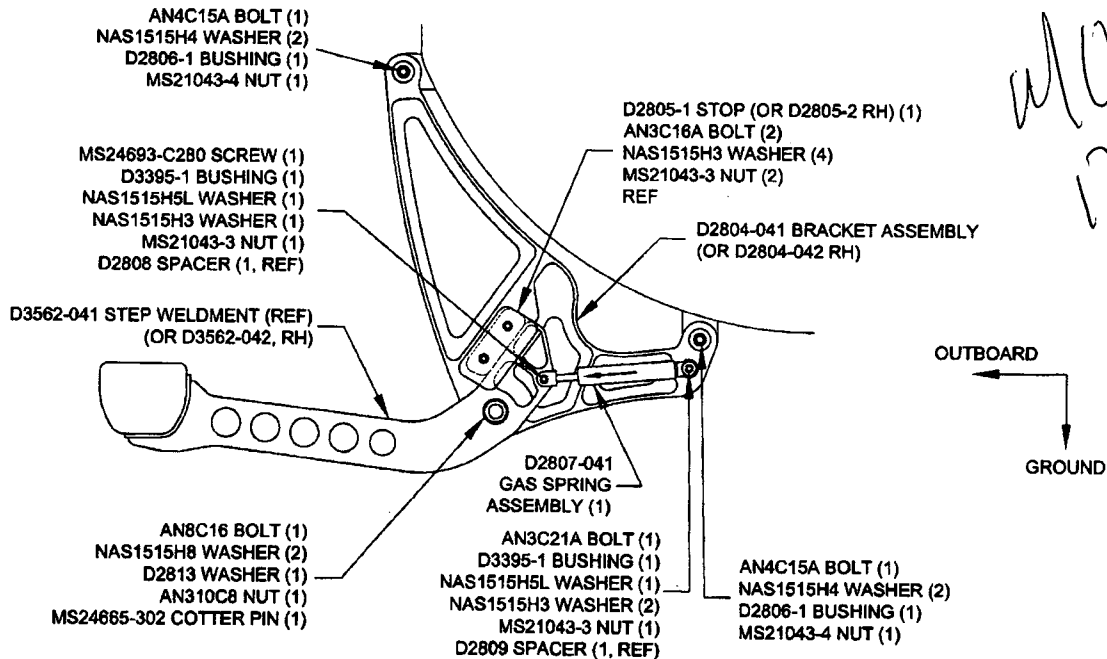
ST265

41

m129172

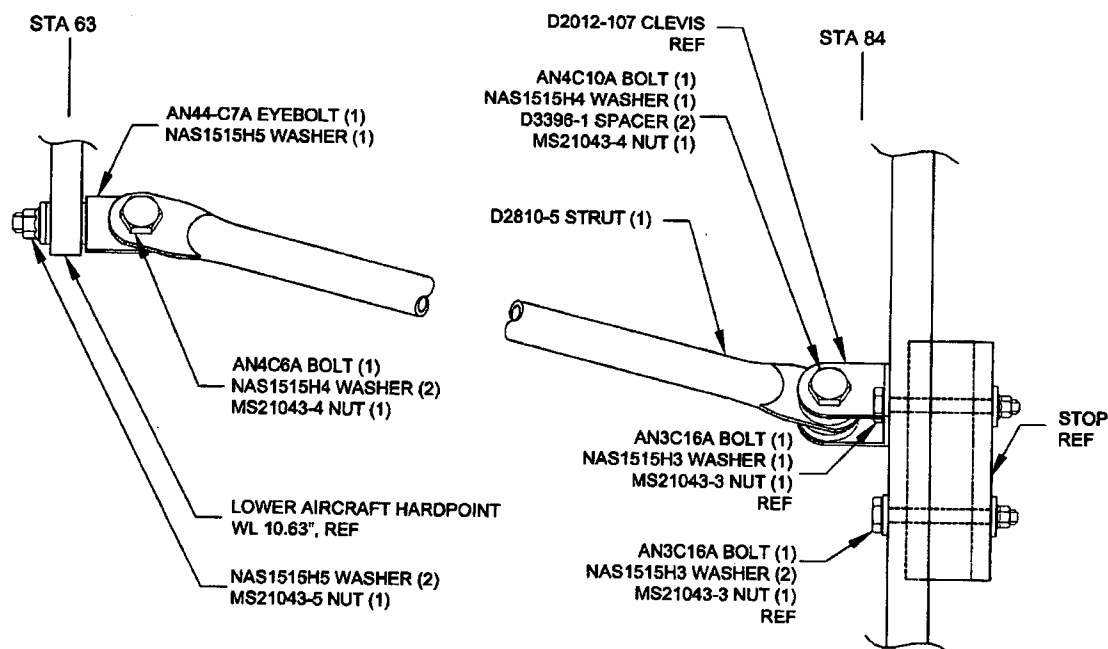
41

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D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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25-00-00



**FIGURE 25-15: Strut Detail for D412-630-033/-034 Heli-Access-Step™ Installation
(NOT TO SCALE)**

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DART AEROSPACE LTD.

DAS
6
9-89

D412-630
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Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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Revision: **N**
Date: 13.09.18